

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021269**Date Inspected:** 25-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 11BE

Shielded Metal Arc Welding (SMAW) in the 3G position of LD to FL3 Panel at PP100, weld joint SEG68B-024 as per ZPMC report # B-WR8645. The welders are identified as 66258. ZPMC Quality Control (QC) is identified as Wang Weiming. The welding variables recorded by QC appeared to comply with WPS-345SMAW-3G (3F)-FCM-Repair-1.

OBG Segment 11DE

Shielded Metal Arc Welding (SMAW) in the 3G position of LD to Floor Beam Panel weld joint SEG072B-042 as per ZPMC report # B-WR9656. The welders are identified as 054013. ZPMC Quality Control (QC) is identified as Tangyajun. The welding variables recorded by QC appeared to comply with WPS-345SMAW-3G (3F)-FCM-Repair.

OBG Segment 8CE

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This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 8CE FL3 Area Holdback & Corner welds

The weld designations reviewed are as follows:

Bottom Stiffeners:-BP026-010-036, 037, 042 and 043

Deck Stiffeners:-SEG048H-049, 050, 058 and 059

SEG048J-122, 123, 158, 159, 095 and 096

Floor Beam Stiffeners / Corner Seams:-SSD16-PP68-170

SSD16-PP70-169

SSD16-PP69-166

FB020-004-PP68-001, 002, 009, 010

FB024-002-PP69-001, 002, 013, 014

FB028-005-PP70-005, 006, 017, 018

OBG Segment 7BW-7DW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as T-Rib Clips as per notification #6055 item # 3

The weld designations reviewed are as follows:

SSD10-PP050-272~274

SSD10A-PP050-272~274

SSD11-PP051-272~274

SSD11A-PP051-272~274

SSD11-PP057-272~274

SSD11A-PP057-272~274

SSD12-PP058-272~274

SSD12A-PP058-272~274

OBG Segment 7BW-7DW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as Corner Assembly as per notification #6055 item # 4

The weld designations reviewed are as follows:

SEG039D-107~109

SSD22-PP57.5-127, 128, 137~140

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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
